

Work Order ID 133900

Tuesday, June 23, 2015 3:14:15 PM

133900

Page 1

Item ID: D4711-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Expandable Pin Assembly
Start Date: 6/23/15 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 6/23/15 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: PLS Date: JUN 24 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4711	C

100 0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 28934
Possible supplier: Mc Master Carr
Supplier P/N: 97787A661
Material release note is required

0.00

62 151 061 24 6

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

6x 8015-0626

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Quality Control

Memo

0.00

60

DAS
38
9-89

JUN 26 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER : _____					

Picklist Print

Tuesday, June 23, 2015 3:14:15 PM

Page 1

Work Order ID: 133900

133900

Parent Item: D4711-043

D4711-043

Parent Item Name: Expandable Pin Assembly

Start Date: 6/23/15

Required Date: 6/23/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:B 12.10.16 AS PER DWG REV.A DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

97787A661

Purchased

No

110

Each

0.0000

1

97787A661

Expandable Pin

**

6
6x 8015-06-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

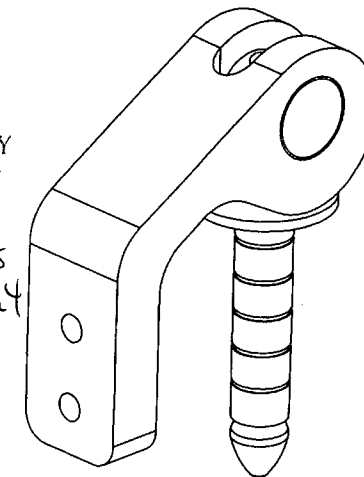
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

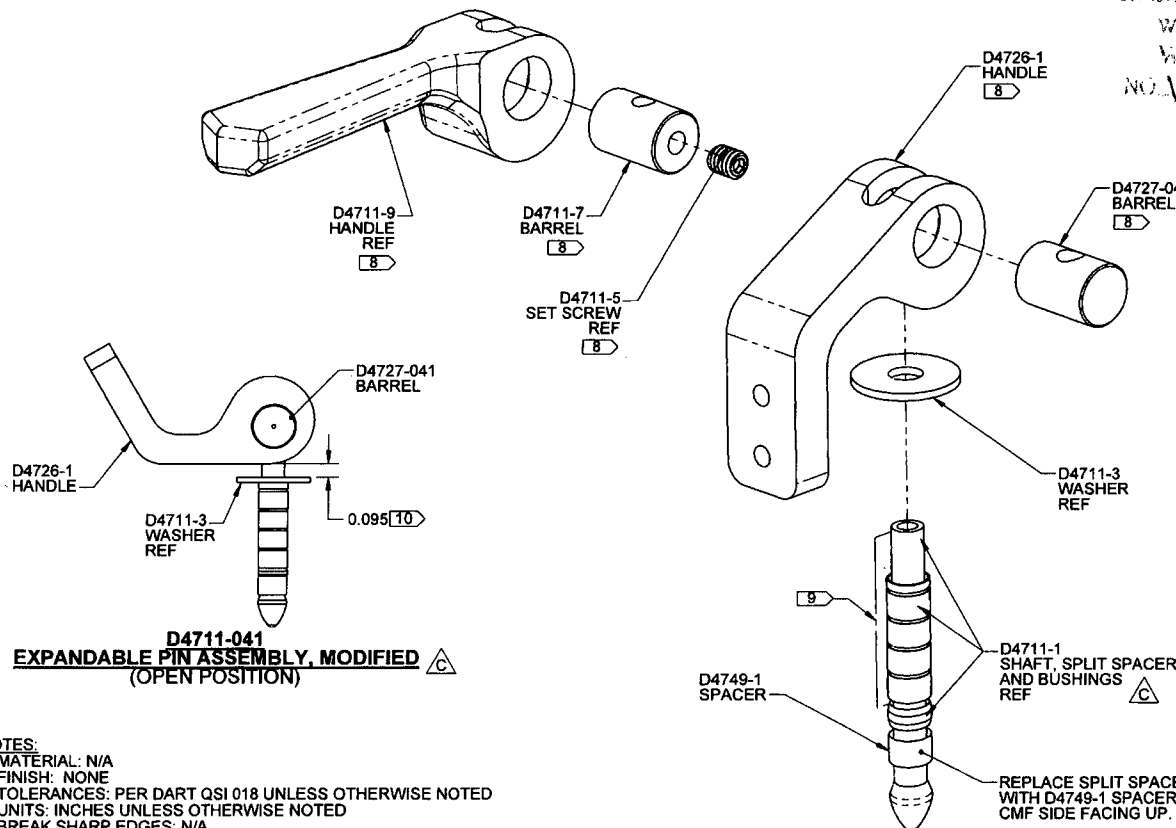
ITEM	QTY	P/N	DESCRIPTION
	X	D4711-041	EXPANDABLE PIN ASSY, MODIFIED
1	1	D4711-043	EXPANDABLE PIN ASSY
2	1	D4726-1	HANDLE
3	1	D4727-041	BARREL
4	1	D4749-1	SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 133900 MLS
150624



**D4711-041
EXPANDABLE PIN ASSEMBLY, MODIFIED
(CLOSED POSITION)**

RELEASED
2013-03-11

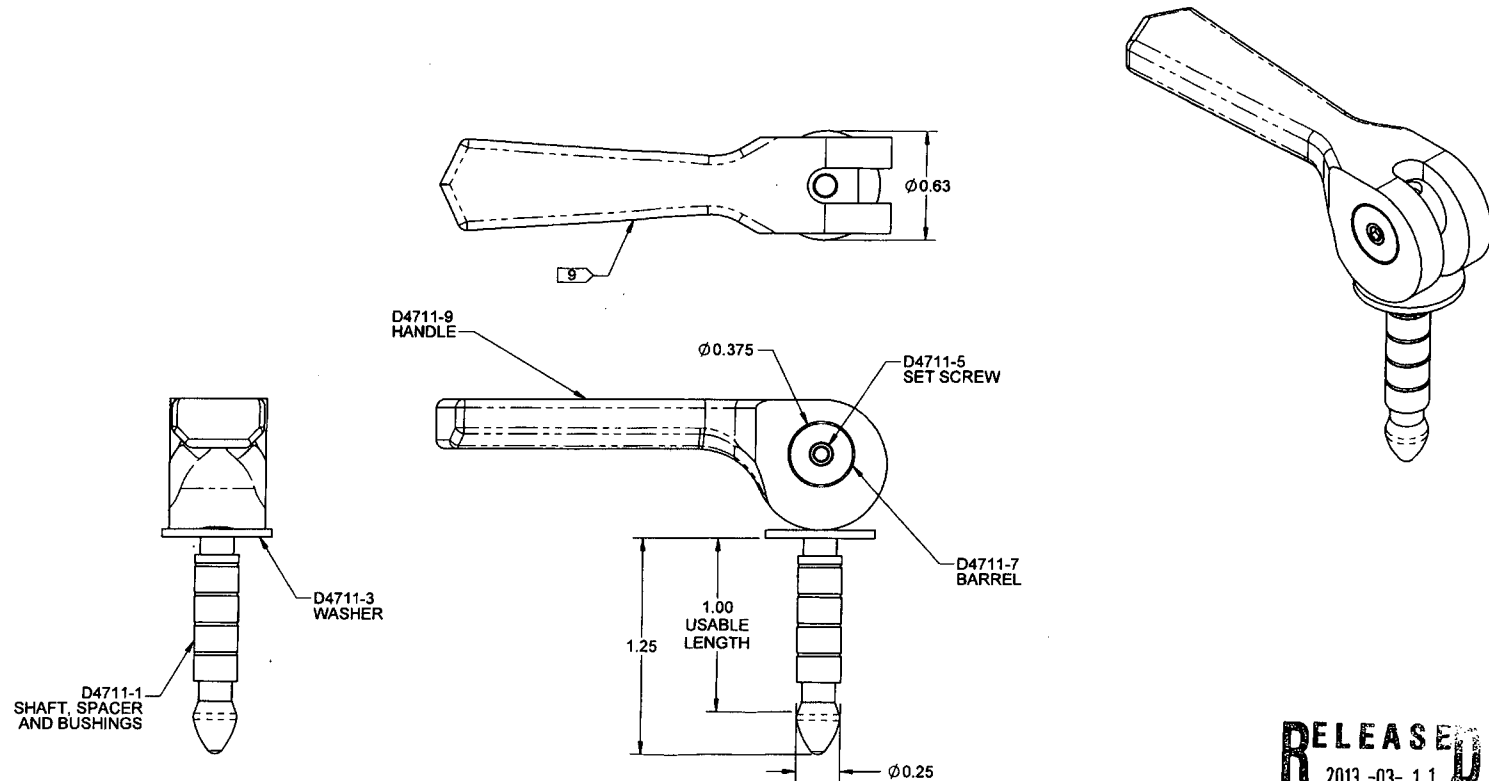


**D4711-041
EXPANDABLE PIN ASSEMBLY, MODIFIED
(OPEN POSITION)**

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4711-041" AND B/N "BXXXXX" PER QSI 044 6.7
 - 7) WEIGHT: 0.19 lbs
 - 8) REPLACE D4711-9 HANDLE WITH DART D4726-1 HANDLE.
REPLACE D4711-7 BARREL WITH DART D4727-041 BARREL.
REPLACE BOTTOM SPLIT SPACER WITH D4749-1 SPACER.
DISCARD D4711-5 SET SCREW, D4711-7 BARREL, D4711-9 HANDLE, BOTTOM SPLIT SPACER.
 - 9) WHEN INSTALLING D4749-1 SPACER, ENSURE THAT ALL RETAINED SPLIT SPACERS AND BUSHINGS REMAIN IN THEIR ORIGINAL SEQUENCE AND ORIENTATION.
 - 10) INSTALL THE D4711-1 SHAFT WITH THE ASSEMBLY IN THE OPEN POSITION, UNTIL A GAP OF 0.095" EXISTS BETWEEN THE D4711-3 WASHER AND THE D4726-1 HANDLE. DO NOT OVERTIGHTEN THE SHAFT INTO THE D4727-041 BARREL.

C	REVISED NOTE (A4-1) & NOTE 8, ADDED NOTE 10. PICTORIAL UPDATE, ADDED VIEW B8-1.	AP	13.02.12
B	ADDED D4749-1 SPACER, MODIFIED NOTES 8 AND 9	AP	12.11.23
A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	AP	D4711	SHEET 1 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	ADJUSTABLE DIAMETER PIN	NTS
DATE	13.02.12	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

SPECIFICATION CONTROL DRAWING



D4711-043 EXPANDABLE PIN ASSY

NOTES:

- 1) MATERIAL: CORE PIN, SPLIT RINGS & BARREL: STAINLESS STEEL 17-4 PH CONDITION H925 PER AMS 5643
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs
- 8) RECOMMENDED SUPPLIER: MCMASTER CARR P/N 97787A661
- 9) HANDLE, BARREL AND SET SCREW TO BE DISCARDED AT NEXT HIGHER ASSEMBLY

DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	21	D4711	SHEET 2 OF 2
APPROVED	12	TITLE	SCALE
DE APPR.	12	ADJUSTABLE DIAMETER PIN	NTS
DATE	13.02.12	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2013-03-11

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28934**

Purchase Order Date 6/24/2015

PO Print Date 6/24/2015

Page Number 2 of 4

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via: Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 10

Currency USD

FOB FCA - (Free Carrier)

Line Total: \$109.44

4 97787A661

Expandable Pin

6/26/2015

Yes

6/26/2015

6.00

Each

\$114.68

\$688.08

AS PER DWG D4711 REV. C
B133900

Line Total: \$688.08

5 59915K274

Rod End Bearing

6/26/2015

Yes

6/26/2015

8.00

Each

\$17.14

\$137.12

AS PER DWG D4777 REV. A
B133948

Line Total: \$137.12

6 71500-30

1326A11 PIN GAUGE

6/26/2015

Yes

6/26/2015

1.00

Each

\$81.70

\$81.70

Note:

6/24/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Jean-Luc
Eric.L

Purchase Order
PO28934
Order Placed By
Chantal Lavoie

McMaster-Carr Number
5170960-03

Page 1 of 1
06/24/2015

Line	Product	Ordered	Shipped
1	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick Your Part Number: B134006	10 Each	10 ✓
2	98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3" Usable Length Your Part Number: B134005	10 Each	10 ✓
4	97787A661 Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length Your Part Number: B133900	6 Each	6 ✓ <i>SP 15-de-26</i>
5	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Your Part Number: B133948	8 Each	8
6	2326A11 Plug Gauge Set, Class Z, .0110"-.0600" Range, Go Gauge, 50 Pieces Your Part Number: 71500-30	1 Each	1
7	2846A129 Single-Flute High-Speed Steel Countersink, 82 Degree Angle, 1-1/4" Body Diameter, 1/2" Shank Diameter Your Part Number: 71500-30	1 Each	1
8	91732A211 18-8 Stainless Steel Standard Helical Insert, 10-24 Internal Thread, .285" Length, MS122120, Packs of 10 Your Part Number: 71500-15	30 Packs	30
9	4714A405 High Performance Multipurpose Sanding Belt, 50 Grit, 3/4" Wide, 20-1/2" Long Your Part Number: 71500-15	25 Each	19

Shipped separately from our Chicago warehouse on 06/24

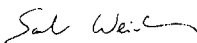
9	4714A405 High Performance Multipurpose Sanding Belt, 50 Grit, 3/4" Wide, 20-1/2" Long	25 Each	6
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McMaster-Carr Supply Company 209 Aurora Industrial Pkwy Aurora, OH 44202-8087 USA Phone: 330-995-5500 Fax: 330-995-9600 E-mail: cle.sales@mcmaster.com Employer Identification Number (EIN): 36-1458720		Invoice: 33018649 Purchase Order: PO28934 Release: McMaster-Carr Number: 5170960-03		ORIGINAL COMMERCIAL INVOICE CERTIFICATE OF ORIGIN	
Ultimate Destination: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada		Shipped: 24-Jun-2015		FOB: ORIGIN	
Intermediate Consignee:		Shipper's Export Declaration (SED): NO EEI 30.36			
Forwarding Agent:		Bill To: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada			
		Tax Number:			
		Billing Attention:			
		Shipping Attention: Jean-Luc Eric.L			
		Contact:			

Line	Description	Qty & Unit	Unit Price	Extension
1	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick B134006 Country of Origin: Peoples Republic of China Schedule B #: 848330 ECCN #: EAR99 NLR	10 EA	\$17.24	\$172.40
2	98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3" Usable Length B134005 Country of Origin: United States Schedule B #: 731829 ECCN #: EAR99 NLR	10 EA	\$3.01	\$30.10
4	97787A661 Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length B133900 Country of Origin: United States Schedule B #: 731829 ECCN #: 9A991 NLR	6 EA	\$114.68	\$688.08
5	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread B133948 Country of Origin: United States Schedule B #: 848330 ECCN #: EAR99 NLR	8 EA	\$17.14	\$137.12
6	2326A11 Plug Gauge Set, Class Z, .0110"-.0600" Range, Go Gauge, 50 Pieces 71500-30 Country of Origin: United States Schedule B #: 903180 ECCN #: EAR99 NLR	1 EA	\$81.70	\$81.70

Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.

These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.

Shipping Weight (in kgs): 3		Number of Packages: 1		Invoice Amounts:	
Package Dimensions: 47 X 21 X 17 CM = .017 CUBIC M				Merchandise Amount: \$1,323.82 Canadian GST/HST: \$173.83 Shipping Charges: \$13.40 Total (In USD): \$1,511.05	
Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days					
Authorized Signature: 		Date: 24-Jun-2015		Remit payment to: (by mail) McMaster-Carr Supply Company PO Box 7690 Chicago, IL 60680-7690 USA	
Name: Sarah Weinberg		Title: Operations Mgr.		(by wire transfer) Bank of America Illinois 231 S LaSalle Chicago, IL 60697 ABA 071000039 Account 86666-02021 SWIFT BOFAUS3N	